

Work Order ID 153114

Tuesday, November 08, 2016 10:52:36 AM

153114

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Item ID: D4434-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Outboard Bracket Assembly
Start Date: 11/18/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/24/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: NOV 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4434	C ✓

100

0.00

100

Small Fab

Memo

0.12

Small Fab

Assemble cover and bracket together as per dwg (SEE NOTE 9)

1 FF JAN 17 2017

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.01

Quality Control

1 DAS 38 9-89

JAN 17 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M1029777</i> Memo *** MASK NUT PLATE HOLES AS PER DWG *** START TIME: <i>7:40</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>8:10</i>	0.00 0.02				<i>1</i>	<i>0</i>	<i>17-01-18</i>	<i>DS 04 9-39</i>
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>	<i>FF</i>	<i>JAN 18 2017</i>	
140 *140* Small Fab Small Fab	Install rubber seal as per dwg A/R 3M 1300 ADHESIVE BATCH: <i>M1134871</i>	0.00 0.06				<i>1</i>	<i>FF</i>	<i>JAN 18 2017</i>	

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐		☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Pressure/Forced ☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Bending ☐	Broken/Damage/Defect ☐	☐	Weld ☐
Handling/Pre ☐	☐	Training ☐	☐	Centre Not Concentric ☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐
Material ☐	☐	Use for Testing ☐	☐	Cracks ☐	Contamination ☐	☐	Out of Sequence ☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crimp/Kink/Ripple/Wave ☐	Countersink ☐	☐	Off-set ☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Cuffs ☐	Cut Too Short ☐	☐	Mislabeled ☐
LOA ☐	☐	Product Improvement ☐	☐	Crushing ☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐
Substation ☐	☐	Process Improvement ☐	☐	Heat Treat ☐	Drill Holes ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	Wave/Twist in Tube ☐	OTHER :		
Misidentified ☐	☐	Past Due ☐	☐	Marks/Chatter ☐			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150					DAS				JAN 18 2017
QC	Memo	0.01			30	1			
Quality Control					9-89				
160		0.00			DAS				
160					30				JAN 18 2017
Packaging	Memo	0.00			9-89	1			
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									17/01/23
QC	Memo	0.03							
Quality Control									

DAS
21
9-89 JAN 19 2017

Picklist Print

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Work Order ID: 153114

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Parent Item: D4434-045

D4434-045

Parent Item Name: Fwd Outboard Bracket Assembly

Start Date: 11/18/2016

Required Date: 11/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24 per
REV.A DD verified by:EC IPP RevD 12.03.05 per REV.B
DD verified by:EC IPP REV:E 13.04.01 AS PER D4434 REV.C
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4434-3 *D4434-3* Bracket		Manufactured	No			100	Each	2.0000	1	2			
									**			JAN 17 2017	
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					ST613			2	B153149				
					151553			2					
D4434-5 *D4434-5* Bracket		Manufactured	No			100	Each	3.0000	1	2			
									**			JAN 17 2017	
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					st612			2					
					151539			2					
					ST613			1					
					148883			1					
D4441-1 *D4441-1* Rubber Seal		Manufactured	No			100	f	0.0001	0.5	1			
									**			JAN 18 2017	
					<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
					ST422			0.0001					
					120932			0.0001					

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Description Work Order Deviation		Disposition			
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D4434-045

Parent Item Name: Fwd Outboard Bracket Assembly

Start Date: 11/18/2016

Required Date: 11/24/2016

Start Qty: 2.00

Required Qty: 2.00

MS20426AD4-4

Purchased

No

100

Each

3,633.000

6

12

MS20426AD4-4

FF JAN 17 2017

Rivet

Location

Loc Qty

Loc Code

GA

1676

125445

1676

ST312

1957

m132536

1957

6

DQA: _____ Date: _____



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